



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-8-2-1

Job Sheet 179844



Part No: C3-8-2-1

Job Qty: 2 ea

Part Name: Solenoid



Part Weight: 0 lbs

Status: At Planning

Priority: Medium

Job Created: 6/22/18

Job Tracking No:

Due Date: 7/11/18 8-17-18

DAS
21
9-00

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG C3-8-2 Rev 3 IPP Rev A 18.04.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		7/11/18	0.00	0.00	Start Up Machining-4		
100	Mill Conv	2 pcs		7/11/18	0.50	0.40	Mill Conv 2		
110	QC	2 pcs		7/11/18	0.00	0.00	QC2 Machining-5		18/8/30
120	QC	2 pcs		7/11/18	0.00	0.00	QC8 Machining-5		18-09-04
130	Packaging	2 pcs		7/11/18	0.00	0.00	Packaging3-2		18-09-04
140	QC21-SA	2 Ea		7/11/18	0.00	0.00	QC21		18-09-04

Part Op 100 - 1-USE C3-8-2-F1 FIXTURE FOR DRILLING THE PIN HOLE. 2-REMOVE COIL SPRING BEFORE DRILLING
Descriptions: HOLE. 3-TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE). 4-Engrave S/N and/or P/N
number using Marktronic engraver as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
152951-001	Solenoid	2 Ea (1 ea)	90-Start up Operation	5082463 6A 169

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	152951-001	2	50	0

Part Specifications

Specifications could not be found.



Container No: S106708



Part: C3-8-2-1

Job No: 179844

Serial No/Batch: S106708

Revision:

Inspector:

Exp Date:

Instructions:

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Plex 6/22/18 1:48 PM Dart.lajeunesse.marie

Date: 08/30/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

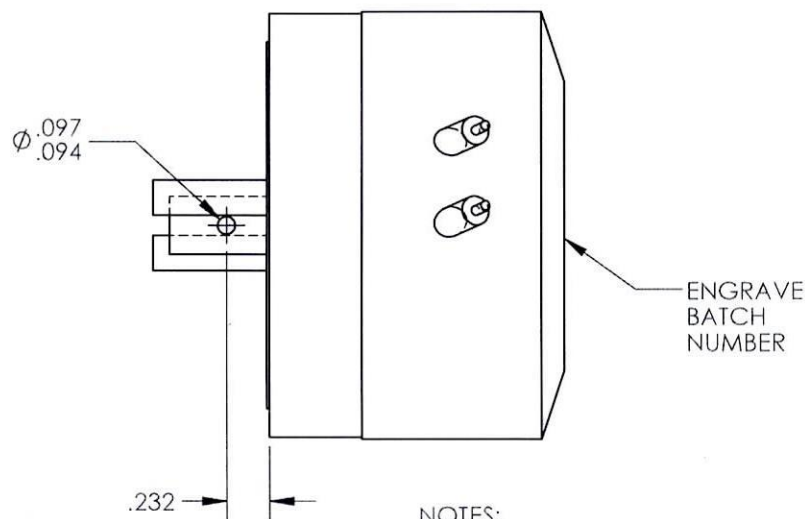
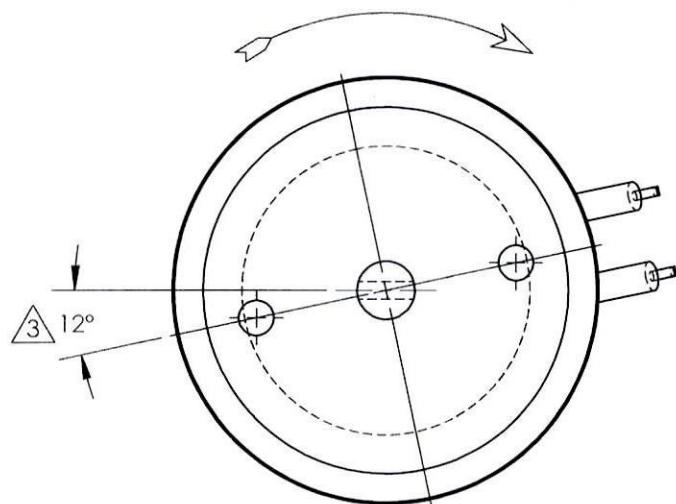
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER : _____									

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	
2	14-0195	C3-8-2-1 CH'D DIM WAS LIMITS Ø.0933-.0937 IS LIMITS Ø.094-.097. ADDED "(CLOCKWISE)" TO NOTE 3. CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE.	10/23/2014	DPD	JAG	



NOTES:

1. USE C3-8-2-F1 FIXTURE FOR DRILLING THE PIN HOLE.
2. REMOVE COIL SPRING BEFORE DRILLING HOLE.
3. TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE).
4. INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING.

(C3-8-2-1)

SOLENOID WITH PINNED HOLE

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: CANAM
.XXX ± .005	APPROVED <i>D Weil</i>
.XX ± .01	HEAT
.X ± .1	TREAT
FRACTIONS ± 1/8	FINISH
ANGLES ± 5°	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 12/19/2001
SHEET 2 OF 4	